

Patent Abstracts of Japan

PUBLICATION NUMBER : 06344377
 PUBLICATION DATE : 20-12-94

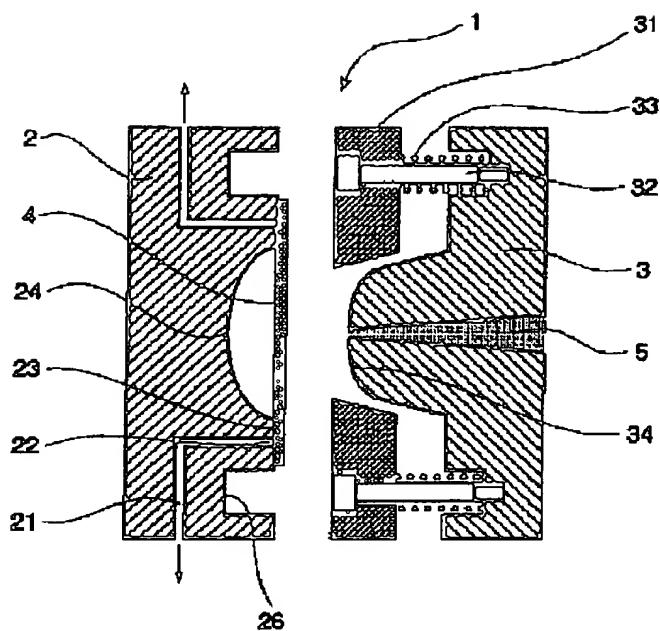
APPLICATION DATE : 07-06-93
 APPLICATION NUMBER : 05159947

APPLICANT : DAINIPPON PRINTING CO LTD;

INVENTOR : KOBAYAMA MITSUYUKI;

INT.CL. : B29C 45/14 B29C 33/14 B29C 45/26 //
 B29K105:20 B29L 9:00

TITLE : DECORATIVE MOLDED PRODUCT
 AND IN-MOLDING METHOD THEREOF



ABSTRACT : PURPOSE: To integrate even a decorative sheet hard to extend with the surface of a molded product without generating wrinkles or breakage by fixing the decorative sheet to the parting surface of a female mold by the stripper plate provided to a male mold and clamping the male and female molds while stretching the decorative sheet by the molded product forming surface of the male mold to perform injection molding.

CONSTITUTION: A stripper plate 31 is arranged to a male mold 3 by a support rod 32 and energized toward a female mold 2 by a spring 33. A spot facing 26 is provided to the part of the female mold 2 corresponding to the support rod 32. A decorative sheet 4 is preparatorily fixed to the parting surface 23 of the female mold by the suction force from the vacuum hole 22 of the female mold 2. In a clamping process, the strip plate 31 comes into contact with the decorative sheet 4 prior to the molded product forming surface 34 of the male mold 3 to fix the decorative sheet 4 to the parting surface 23 of the female mold 2. Subsequently, the molded product forming surface 24 of the male mold comes into contact with the decorative sheet 4 to stretch the sheet 4 and, after the completion of mold clamping, a molten resin is injected.

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